

Date: Wednesday, 24/09/2008 12:49:01 PM
User: Julie Lecocq

Process Sheet

Customer : CC-EUR01 Eurocopter France	Drawing Name : LONG STEP ASSEMBLY HIGH SKID RH
Job Number : 42275	
Estimate Number : 13561	
P.O. Number :	Part Number : D350591312
This Issue : 24/09/2008 S.O. No. :	Drawing Number : D3272 REVB-EUROCOPTR
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : B
Previous Run : 40793	Material :
	Due Date : 03/11/2008 Qty: 10 Um: Each
Written By :	
Checked & Approved By : <u>JUD 08.9.24</u>	
Comment : Est Rev:A 04.03.22 New issue KJ/RF	
Est Rev:B 07-06-09 Added D3572-1 JLM	
Est. returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

SP 08.12.12

2.0	D32721	Step
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✓



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STEP

BATCH: B 42412

SP

08.12.03

3.0	D30671	End Plate
-----	--------	-----------

✓



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate

B 41447

SP

08.12.03

4.0	D32191	Plate
-----	--------	-------

✓



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3219-1

Support

B 42992

SP

08.12.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D350591312

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Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

11 109213
11 104855

SP 08.12.04

10x

3-Grind End Plate flush

SAD 08-12-04

10x

6.0

QC9

VISUAL WELDING INSPECTION



10/08/12/04



Comment: VISUAL WELDING INSPECTION

EBE 08-12-04

10x

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/04 10xRH

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/12/05

10xRH

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.12.04 10xRH

10.0

D3065041

Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B42344
B42344

SAD 08-12-08

11.0

D30661

Spacer



Comment: Qty.: - 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B42345

SAD 08-12-08 10x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 42275

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4 Rivet *M109545*

SAD 08-12-08

(10X)

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

SAD 08-12-08

10

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08-12-08

(10X)

15.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1 End Plate *B 41447*

SP 08.12.08

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M104855*

4-Grind End Plate flush

5-Install last rivet.

SP 08.12.08. (10X)

SAD 08-12-08

(10X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 42275

Part Number: D350591312

Job Number:



Seq. #: Machine Or Operation: Description :

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 08/12/09 (10)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/12/10 (10) RHC

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

Handwritten: M-1

Handwritten: 08/12/10

Handwritten: 10X RH

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten: 1:40
320 °F
2:10

Handwritten: M-1 08/12/10

Handwritten: 10X RH

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

Handwritten: M-1

Handwritten: 08-12-10

Handwritten: 10X RH

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

Handwritten: FL

Handwritten: 08/12/11

Handwritten: (10)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D22303

Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug

Handwritten: B42316

Handwritten: 08/12/11

Handwritten: 10X

Handwritten: 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 42275

Part Number: D350591312

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

25.0	D2618	Bushing
------	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618 Bushing 41028

JS 08/12/15 (X10)

26.0	D2856400	Abraison Strip
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Comment: Qty.: 0.6000 f(s)/Unit Total: 6.0000 f(s)

Abraison Strip

2 x D2856-400-720 42076

JS 08/12/15 (X10)

27.0	D32351	Mounting Lug
------	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1 Mounting Lug B41342

JS 08/12/11 50

28.0	D3278041	Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 Support Assembly B42320

JS 08/12/11 30

29.0	AN335A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M108827

JS 08/12/15 (X10)

30.0	AN413A	Bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Bolt

batch: M109285

JS 08/12/15 (X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 42275

Part Number: D350591312

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

31.0	AN536A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A Bolt

M109545

SS 08/12/15 (X10)

32.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer

M109000

SS 08/12/15 (X10)

33.0	AN960JD416	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416 Washer

M109249

SS 08/12/15 (X10)

34.0	AN960JD516	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

M109282

SS 08/12/15 (X10)

35.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

M108816

Batch not in comp

SS 08/12/15 (X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 42275

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M108145

37.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

M109297

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-312

Location:

Res D

8/12/17

510

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>90</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

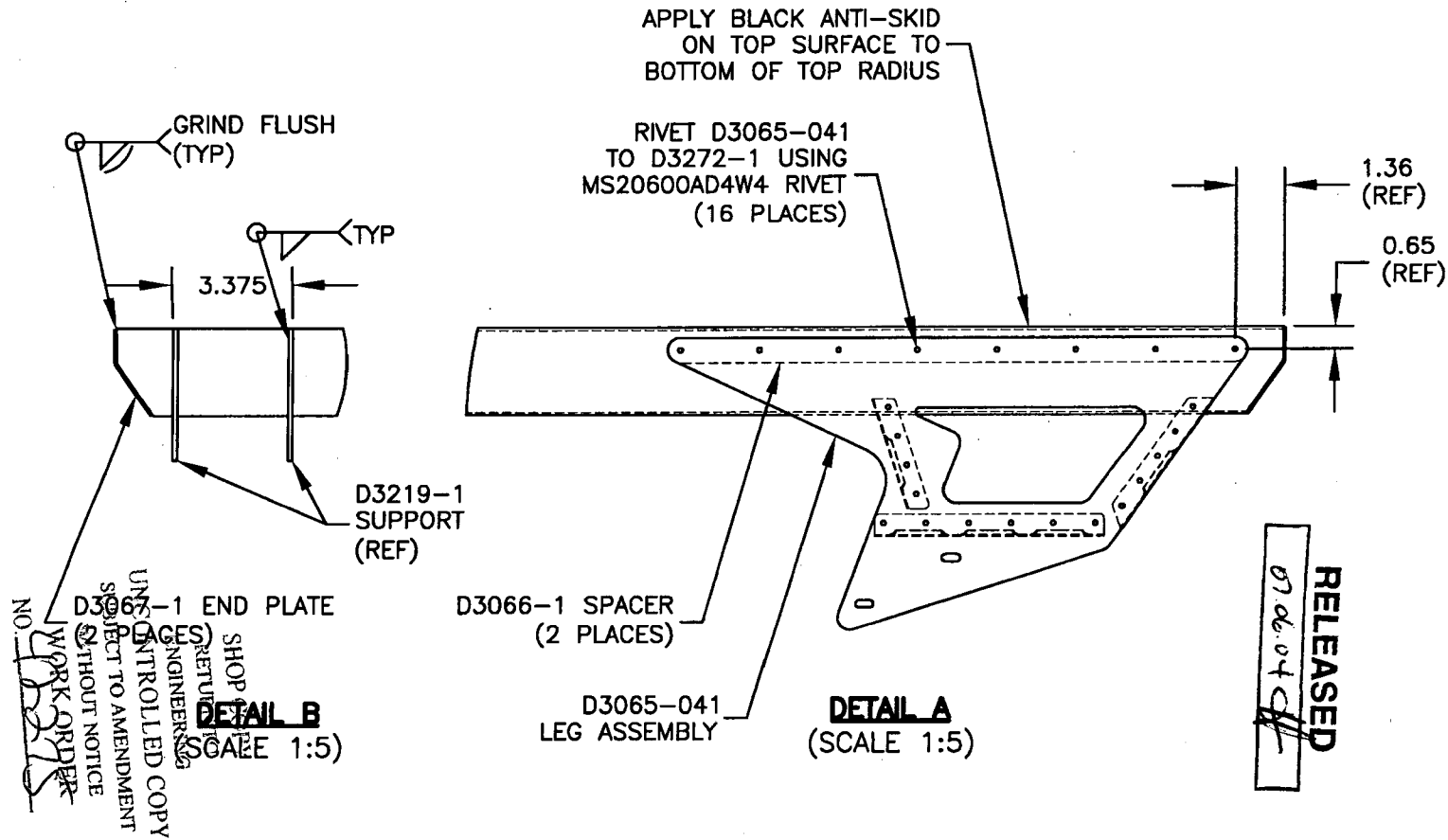
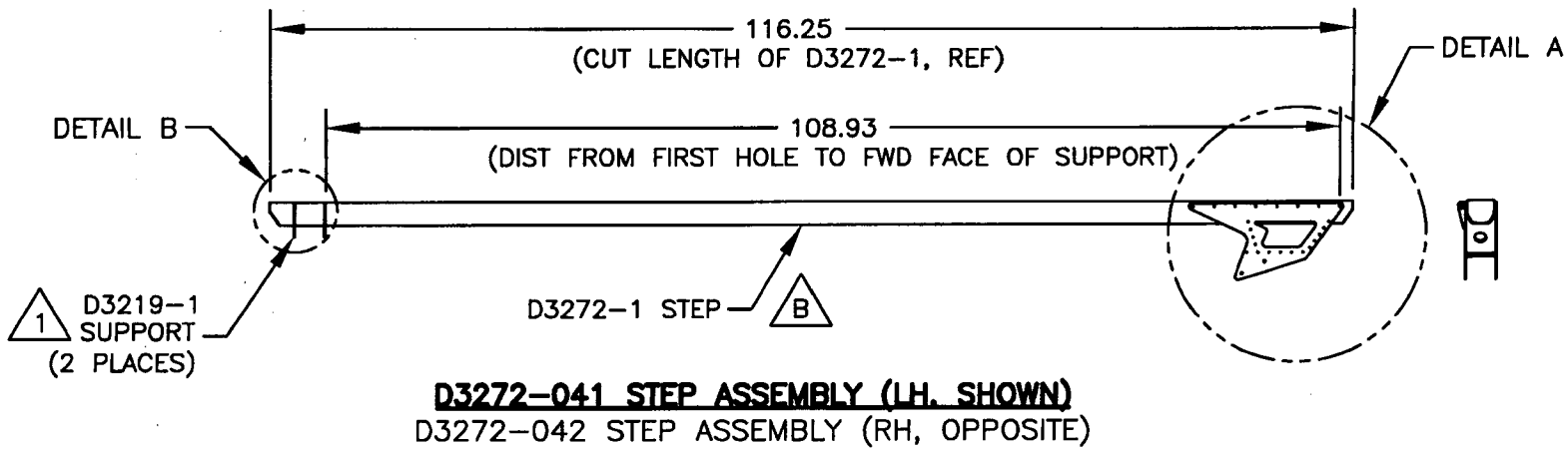
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WORK ORDER
NO. *42215*

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DART

DESIGN	90	DRAWN BY	JB	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	CE	APPROVED	[Signature]	DRAWING NO.	REV. B
				D3272	SHEET 2 OF 3
DATE	07.05.18			TITLE	SCALE
				STEP ASSEMBLY, HI LONG	1:20



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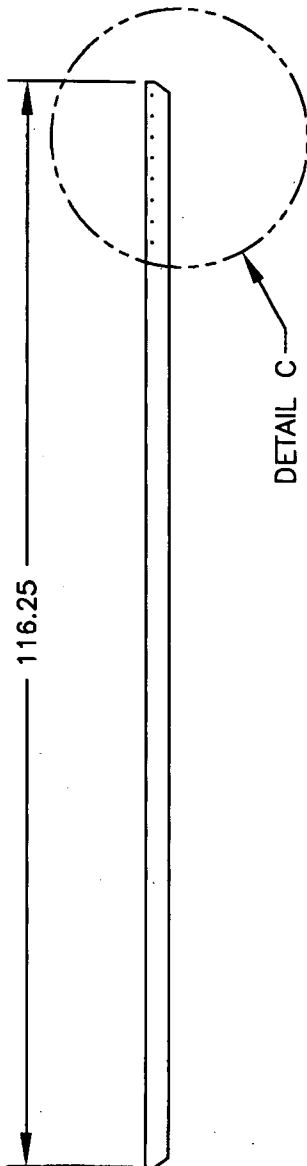
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DART

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

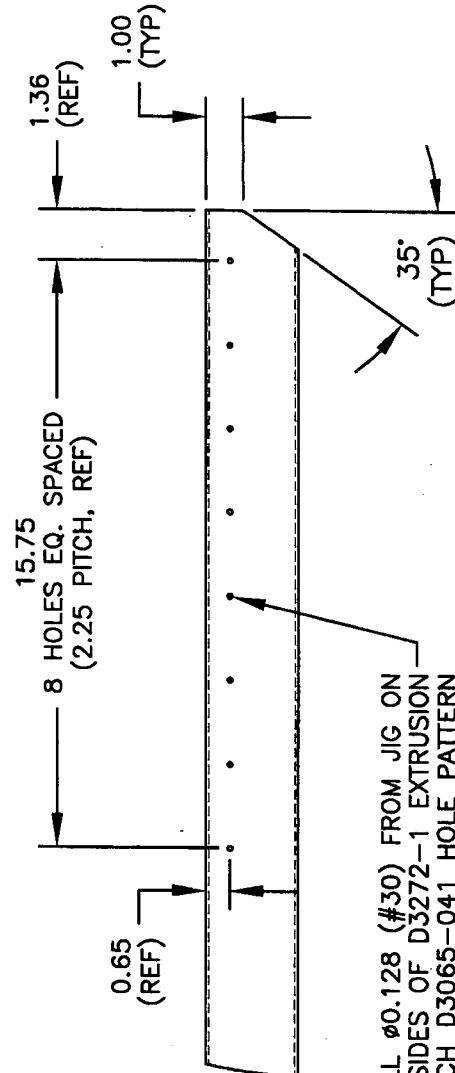
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *42275*

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